

Date: Monday, 2/11/2008 2:11:59 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, OUTBOARD, LH, 206
Job Number : 37330	
Estimate Number : 10818	
P.O. Number :	Part Number : D26651
This Issue : 2/11/2008 S.O. No. :	Drawing Number : D2665 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 35803	Material :
Written By :	Due Date : 2/28/2008 Qty: 10 Um: Each
Checked & Approved By : <u>08 02 11</u>	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC	
Est Rev:D As per Rev D 07-03-19 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 7075-T7351 2X6.25X7.875  
 Cut Size 2.0" x 6.25" x 7.88"  
 Grain Along Long 7.88 Length

Batch no. 34873 ~~63554~~ x 10.

SF 08/04/29

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Program batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 3-Fixturing Inspection last completed on 08/04/29 by DF  
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  
 7- Deburr

PTO →

SF 08/04/29

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

DSP 08/05/01

4.0	QC2.	INSPECT PARTS AS THEY COME OFF MACHINE
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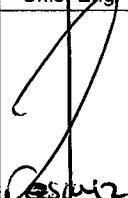

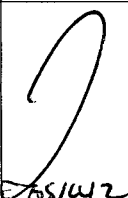

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 08/05/01

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2665-1 PAR #: N/A Fault Category: Prod / machined NCR: ☒ Yes No DQA: D Date: 08/05/16  
QA: N/C Closed: D Date: 08/05/16

NCR: 37330		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/29	2.0	wrong long setup take jig # DT 8729-3. The good jig was DT 8729-1. RC operator order he took wrong origin, and the incorrect tool.		Scrap and Destroy and replace with BA 34873 button to correct jig	St 08/04/29	 08.05.02	 08/05/12	 08/04/29

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 37330

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08-05-02

10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BK

08-05-05

10

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11107550

91

08-05-05

B37330  
D 26651  
05/05/2008  
S. 190 15.23  
#1 721.5 F  
#2 --- F  
#3 30 MIN F  
#4 --- F

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF

08/05/05

10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST436

AS

08/05/06

10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/06

Job Completion



MF 08-05-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	37330
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2665-1
<b>Inspection Dwg:</b> D2665 Rev. D		Page 1 of 1

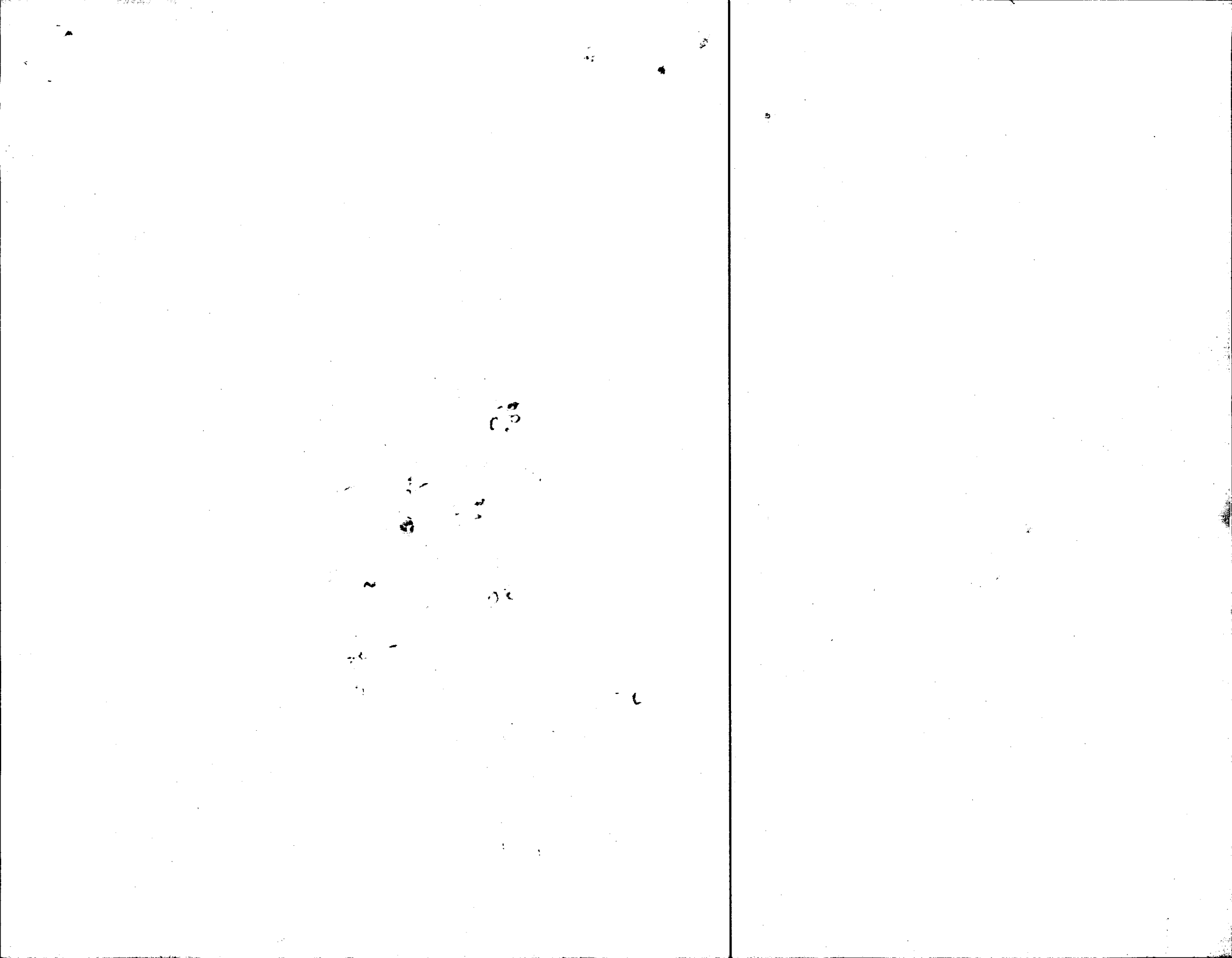
Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.121	.122	.125		
B	0.100	0.140		.118	.125	.125	.125		
C	1.125	1.145		1.132	1.131	1.131	1.131		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.255	.257	.258	.255		
F	1.313	1.343		1.324	1.321	1.324	1.325		
G	0.210	0.230		.220	.220	.224	.225		
H	0.100	0.180		.165	.165	.170	.165		
I	2.470	2.510		2.495	2.500	2.500	2.500		
J	1.565	1.585		1.575	1.574	1.571	1.571		
K	0.235	0.240		.237	.237	.237	.237		
L	0.100	0.120		.110	.107	.110	.107		
M	0.990	1.010		1.006	1.000	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.001	6.001	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	.313		
S	0.315	0.322		.321	.321	.321	.321		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.363		
V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.542	.555	.552	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.925	.925	.925	.925		
AA	0.490	0.510		.500	.500	.500	.501		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	RF
Date:	08/04/29

Audited by:	RF
Date:	04.05.02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 37330
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2665-1
<b>Inspection Dwg:</b> D2665 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	54	62	78	94		
A	0.100	0.140		.125	.125	.118	.119		
B	0.100	0.140		.120	.120	.125	.125		
C	1.125	1.145		1.131	1.131	1.134	1.132		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.257	.257	.258	.255		
F	1.313	1.343		1.324	1.324	1.325	1.321		
G	0.210	0.230		.222	.222	.220	.220		
H	0.100	0.180		.165	.165	.170	.165		
I	2.470	2.510		2.500	2.500	2.500	2.500		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		0.236	0.236				
L	0.100	0.120		.107	0.108	0.108	0.108		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515							
O	5.990	6.010		6.001	6.002	6.002	6.002		
P	1.245	1.255		1.250	1.247	1.248	1.249		
Q	2.495	2.505		2.500	2.498	2.500	2.499		
R	0.313	0.318		.313	0.314	0.314	0.314		
S	0.315	0.322		.321	.321	.321	.321		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.802	.802	.802	.800		
W	0.540	0.560		.550	.550	.550	0.548		
X	1.674	1.684		1.682	1.682	1.681	1.681		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.927	.927	.926	.926		
AA	0.490	0.510		.502	0.493	0.501	0.502		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>DTP</u>	Audited by: <u>SC</u>
Date: <u>08/05/01</u>	Date: <u>08-05-02</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>37330</b>
<b>Description: 206 Saddle, Outboard, Left side</b>	<b>Part Number:</b>	<b>D2665-1</b>
<b>Inspection Dwg: D2665 Rev. D</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	3	4		
A	0.100	0.140		.118	0.124				
B	0.100	0.140		0.123					
C	1.125	1.145		1.132	1.132				
D	0.615	0.685		.665	0.650				
E	0.240	0.260		0.255					
F	1.313	1.343		1.321	1.3245				
G	0.210	0.230		.221	0.222				
H	0.100	0.180		0.165					
I	2.470	2.510		2.500	2.495				
J	1.565	1.585		1.5715	1.572				
K	0.235	0.240							
L	0.100	0.120		0.108	0.108				
M	0.990	1.010		1.000	1.000				
N	0.510	0.515							
O	5.990	6.010		6.002	6.002				
P	1.245	1.255		1.249	1.250				
Q	2.495	2.505		2.500	2.498				
R	0.313	0.318		0.314	0.314				
S	0.315	0.322		.322	.322				
T	2.495	2.505		2.500	2.498				
U	1.357	1.367		1.362	1.363				
V	0.787	0.807		.800	0.800				
W	0.540	0.560		0.553	0.553				
X	1.674	1.684		1.681	1.681				
Y	0.257	0.262		.258	.259				
Z	0.912	0.932		.926	0.926				
AA	0.490	0.510		0.502	0.502				
AB	0.178	0.198		.188	0.188				
AC									
AD									
AE									
AF									
Accept/Reject									

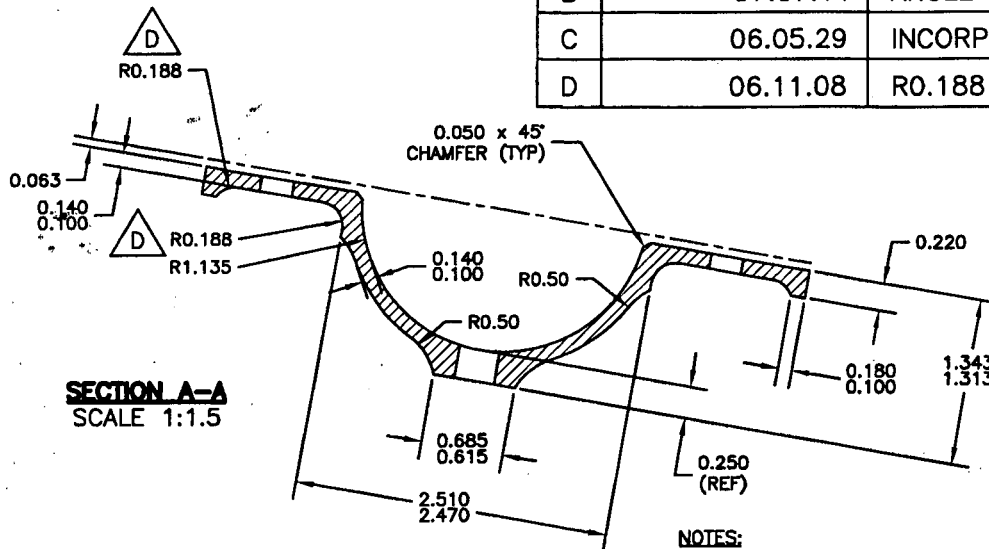
Measured by: <b>DTP</b>	Audited by: <b>SC</b>
Date: <b>08/05/01</b>	Date: <b>08-05-02</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

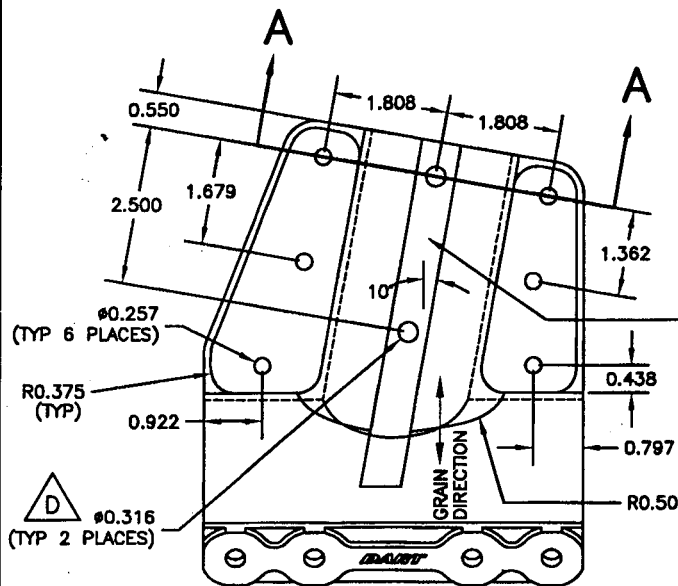


RELEASED

07.02.12

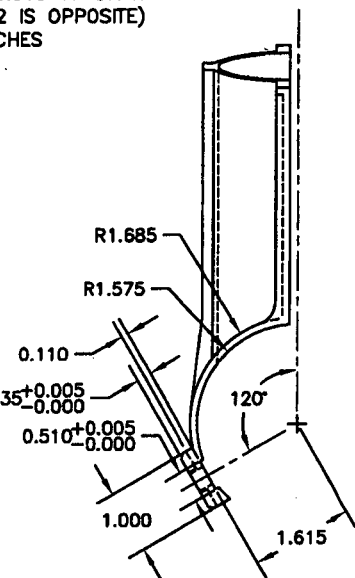
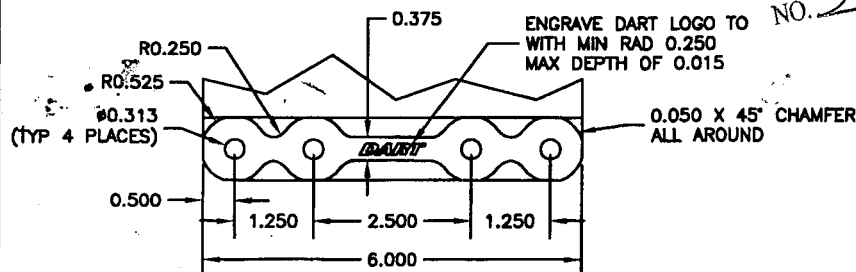
## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37330

**D2665-1 SADDLE FWD OUTSIDE HIGH**

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